

Work Order ID 70164



Page 1

Monday, May 30, 2011 12:44:16 PM

Item ID:	D2916-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Cable Guard, 212 Skitube					
Start Date:	5/30/2011	Start Qty:	4.00	Cust Item ID:		
Required Date:	6/8/2011	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>14</u>	Date:	<u>11-05-30</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2916	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D2916	<input type="checkbox"/> Dwg Rev: <u>B</u>							
	Deburr if necessary	<input type="checkbox"/> Prog Rev: <u>B</u>							

1B1-6-8

4

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

1B1-6-8

120	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo	0.00							
	BATCH: <u>116554</u>	<input type="checkbox"/> 1- Mill as per Folio FA2916-3 Rev:							
	<u>AA</u> & Dwg D2916 Rev: <u>B</u>	<input type="checkbox"/> 2-Deburr per dwg D2916							

BA 11/06/15

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries

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Revision ID:
Item Name: Cable Guard, 212 Skitube Stop 
Start Date: 5/30/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 6/8/2011 Req'd Qty: 4.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	BA	11/06/15		4	0		
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	11/06/15					(H)
150  Packaging Packaging	Identify as per dwg & Stock Location: 207 Memo	0.00 0.00							11/6/15 SP (Y)

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Start Date: 5/30/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 6/8/2011 Req'd Qty: 4.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

u/c/15 
10/11-06-15
(4)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, May 30, 2011 12:44:22 PM

Page 1

Work Order ID: 70164



Parent Item: D2916-3



Parent Item Name: Cable Guard, 212 Skitube

Start Date: 5/30/2011

Required Date: 6/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-19 JLM
IPP Rev:B Now water jet 06-07-14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10		Purchased	No			100	sf	381.6000	0.55	2.315789			
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1311-6-8

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

381.6

116554

2

117321

76.6

117738

63

117819

240

116554

4

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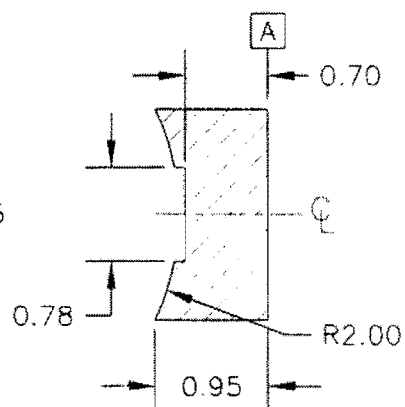
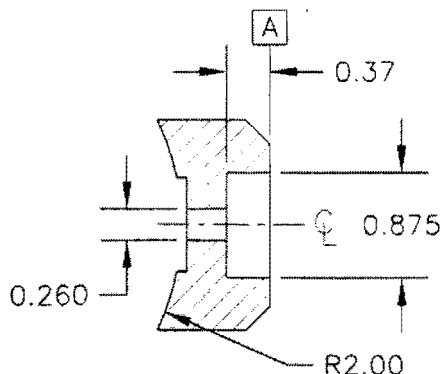
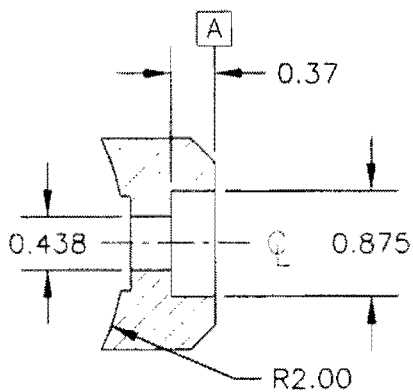
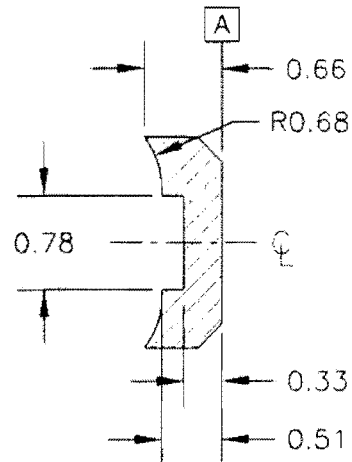
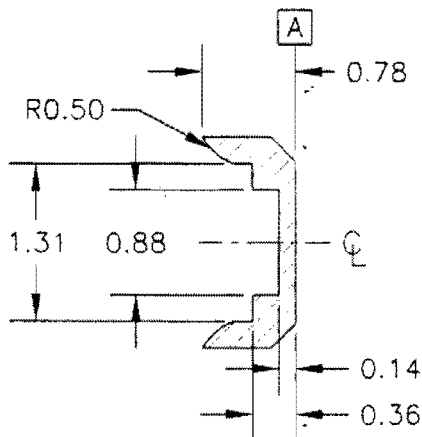
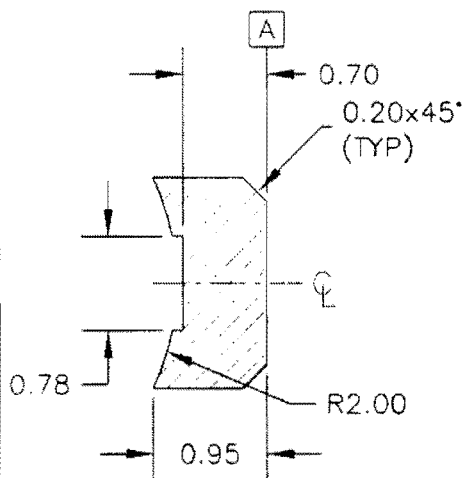
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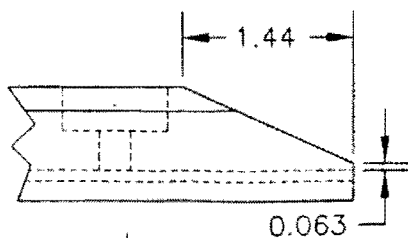
NOTE: Date & initial all entries



DESIGN #	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70664



DETAIL J
(SCALE 2:3)

RELEASED
007-02-25 DS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

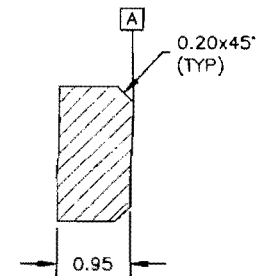
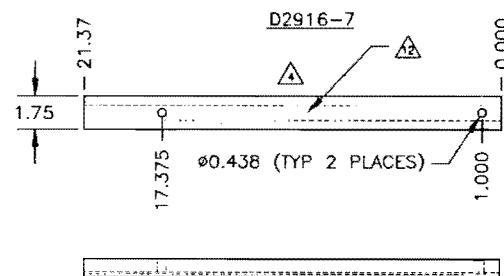
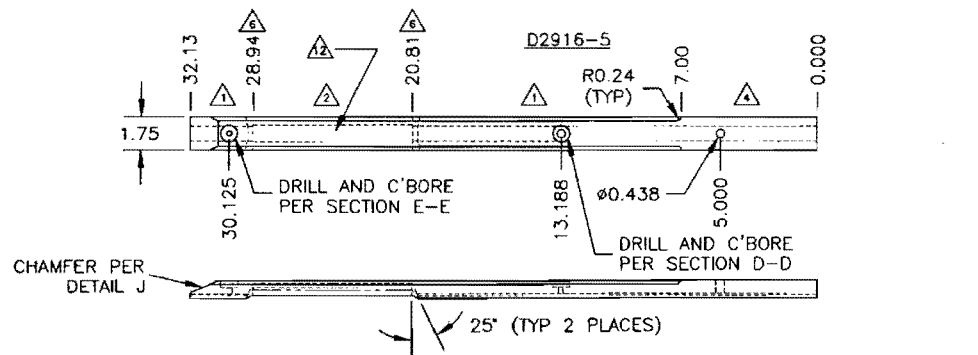
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

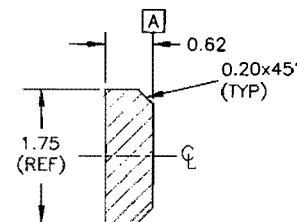
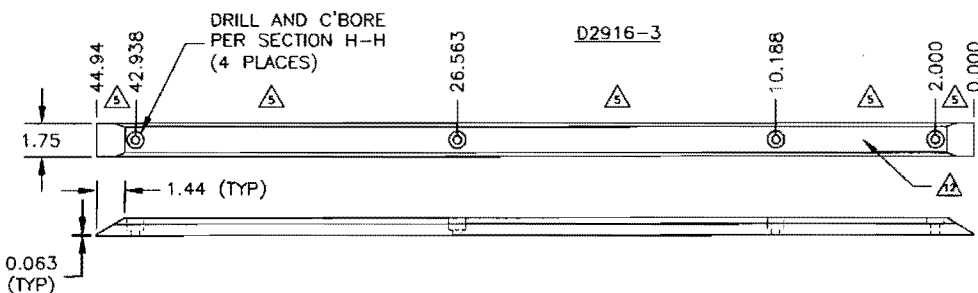
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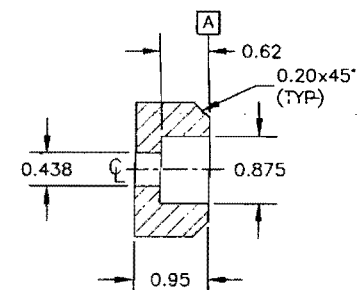
also 7064



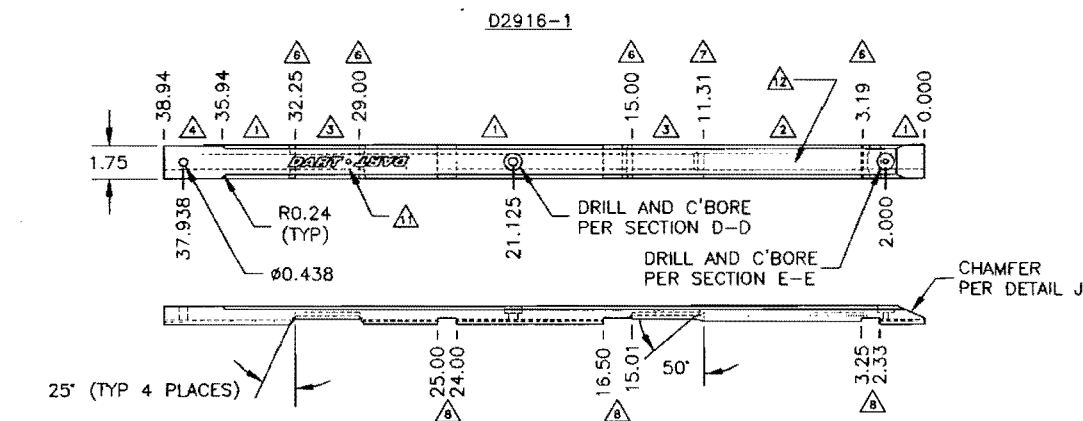
SECTION G-G
(SCALE 2:3)



SECTION K-K
(SCALE 2:3)



SECTION H-H
(SCALE 2:3)



- NOTES:
- 1) MACHINE CONSTANT SECTION A-A
 - 2) MACHINE CONSTANT SECTION B-B
 - 3) MACHINE CONSTANT SECTION C-C
 - 4) MACHINE CONSTANT SECTION F-F
 - 5) MACHINE CONSTANT SECTION G-G
 - 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
 - 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
 - 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
 - 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
 - 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
 - 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
 - 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
 - 13) ALL HOLES DRILLED ON CENTERLINES
 - 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 15) ALL DIMENSIONS ARE IN INCHES

RELEASED
100.02.25.03

DESIGN #	DRAWN BY P	DART DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA	REV. B
CHECKED #	APPROVED #	DRAWING NO. D2916	SHEET 2 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6

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